

 **BOEING**  
COMPONENT  
MAINTENANCE MANUAL

TO: ALL HOLDERS OF TRUNNION DOOR ASSEMBLY COMPONENT MAINTENANCE MANUAL 32-12-61

REVISION NO. 11 DATED MAR 01/02

HIGHLIGHTS

Pages which have been added or revised are outlined below together with the highlights of the revision. Remove and insert the affected pages as listed and enter Revision No. and date to the Record of Revision Sheet.

CHAPTER/SECTION

AND PAGE NO.

DESCRIPTION OF CHANGE

REPAIR-GEN

Added clarifications and updated callouts.

602

REPAIR 1-1

601

REPAIR 2-1

601

REPAIR 1-1

Added more details of the 113T8316-series fittings.

602-605

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HIGHLIGHTS

01.1

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## TRUNNION DOOR ASSEMBLY

PART NUMBERS 113T8301-15SP,-16SP,-17,-18,  
-21SP,-22SP,-27SP THRU  
-30SP

COMPONENT MAINTENANCE MANUAL  
WITH  
ILLUSTRATED PARTS LIST

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TITLE PAGE

Page 1

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01.1



REVISION RECORD

- Retain this record in front of manual. On receipt of revision, insert revised pages in the manual, and enter revision number, date inserted and initial.

REVISION NUMBER	REVISION DATE	DATE FILED	BY	REVISION NUMBER	REVISION DATE	DATE FILED	BY



TEMPORARY REVISION AND SERVICE BULLETIN RECORD

BOEING SERVICE BULLETIN	BOEING TEMPORARY REVISION	OTHER DIRECTIVE	DATE OF INCORPORATION INTO MANUAL
		PRR B10450-2 PRR B10482 PRR B13100-2	OCT 10/83 OCT 10/84 MAR 01/00

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TR & SB RECORD

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2	BLANK		*603	MAR 01/02	01.1
REVISION RECORD			*604	MAR 01/02	01.1
1	JUL 10/83	01	*605	MAR 01/02	01.1
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LIST OF EFFECTIVE PAGES			603	SEP 01/94	01.1
*1	MAR 01/02	01	604	BLANK	
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2	BLANK		FITS AND CLEARANCES		
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*602	MAR 01/02	01.1	1009	MAR 01/00	01.1
			1010	MAR 01/00	01.1
			1011	MAR 01/00	01.1
			1012	MAR 01/00	01.1
			1013	MAR 01/00	01.1
			1014	MAR 01/00	01.1
			1015	MAR 01/00	01.1
			1016	MAR 01/00	01.1

\* = REVISED, ADDED OR DELETED

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PAGE	DATE	CODE	PAGE	DATE	CODE
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1017	MAR 01/00	01.1			
1018	MAR 01/00	01.1			

\* = REVISED, ADDED OR DELETED

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\* [1] Special instructions are not required. Use standard industry practices and the instructions in SOPM 20-30-01 and 20-30-03.



## INTRODUCTION

The instructions in this manual provide the information necessary to perform maintenance functions ranging from simple checks and replacement to complete shop-type repair.

This manual is divided into separate sections:

- |  |                              |
|--|------------------------------|
| 1. Title Page                                      | 4. List of Effective Pages   |
| 2. Record of Revisions                             | 5. Table of Contents         |
| 3. Temporary Revision &<br>Service Bulletin Record | 6. Introduction              |
|  | 7. Procedures & IPL Sections |

Refer to the Table of Contents for the page location of applicable sections. An asterisked flagnote \*[ ] in place of the page number indicates that no special instructions are provided since the function can be performed using standard industry practices.

The beginning of the REPAIR section includes a list of the separate repairs, a list of applicable standard Boeing practices, and an explanation of the True Position Dimensioning symbols used.

An explanation of the use of the Illustrated Parts List is provided in the Introduction to that section.

All weights and measurements used in the manual are in English units, unless otherwise stated. When metric equivalents are given they will be in parentheses following the English units.

Design changes, optional parts, configuration differences and Service Bulletin modifications create alternate part numbers. These are identified in the Illustrated Parts List (IPL) by adding an alphabetical character to the basic item number. The resulting item number is called an alpha-variant. Throughout the manual, IPL basic item number references also apply to alpha-variants unless otherwise indicated.

Verification:

| Assembly: June 19, 1986

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INTRODUCTION

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TRUNNION DOOR ASSEMBLY

DESCRIPTION AND OPERATION

1. Description and Operation

A. The trunnion door assembly is a hinged, honeycomb-core door which, together with the shock strut door assembly and drag strut door assembly, closes over the main landing gear. The trunnion door assembly is operated by the main landing gear through the actuation link assembly attached to the trunnion door hinges.

2. Leading Particulars (Approximate)

Width -- 7 inches  
Length -- 34 inches  
Height -- 30 inches  
Weight -- 16 pounds

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DESCRIPTION & OPERATION

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DISASSEMBLY

NOTE: Disassemble this component only as necessary for fault isolation, to find the serviceability of parts, do the repairs and put the unit back in serviceable condition.

A. Use standard industry practices and these steps.

CAUTION: THE EDGES OF FITTINGS (100, 105, 160) WERE INSTALLED WITH BMS 5-95 SEALANT. BE CAREFUL NOT TO DAMAGE THE STRUCTURE WHEN YOU REMOVE THE FITTINGS.

B. Remove fittings (100, 105, 160) by the special instructions in SOPM 20-10-08.

C. Make a note of the thickness of laminated shim (75, 150) for help during installation of the door on the airplane.

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DISASSEMBLY

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CHECK

1. Examine all parts for obvious defects with standard industry practices. Refer to Fits and Clearances for design dimensions and wear limits. Do the penetrant check only if the visual check finds possible defects.
2. Penetrant check per 20-20-02 -- Fittings (100, 105, 160, IPL Fig. 1).
3. Examine honeycomb and bonded parts for signs of delamination, water, scratches, and contour defects.
  - A. Examine for delamination ultrasonically.
  - B. Radiographically examine areas that could contain water.
  - C. Examine the edges of the panels carefully for cuts and abrasions. Delamination starts very easily from damage to an edge of the honeycomb panel.
4. Refer to 767 Structural Repair Manual 52-80-02 for damage limits and repair instructions.

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CHECK

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REPAIR – GENERAL1. Content

- A. Repair, refinish and replacement procedures are included in separate repair sections as follows:

<u>P/N</u>	<u>NAME</u>	<u>REPAIR</u>
113T8316	FITTING ASSEMBLY	1-1
113T8313	FITTING ASSEMBLY	2-1
- -	MISCELLANEOUS PARTS REFINISH	3-1

2. Standard Practices

- A. Refer to the following standard practices overhaul manuals, as applicable, for details of procedures in individual repairs.

20-00-00	Introduction
20-30-02	Stripping of Protective Finishes
20-30-03	General Cleaning Procedures
20-41-01	Decoding Table for Boeing Finish Codes
20-41-02	Application of Chemical and Solvent Resistant Finishes
20-43-01	Chromic Acid Anodizing
20-50-03	Bearing and Bushing Replacement
20-60-02	Finishing Materials
20-60-03	Lubricants
20-60-04	Miscellaneous Materials

3. Materials

NOTE: Equivalent substitutes can be used.

- A. Enamel -- BMS 10-11, Type 2, color BAC702 white gloss (SOPM 20-60-02)

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REPAIR-GENERAL

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B. Enamel -- BMS 10-60, Type 2 gloss in the airline's standard color scheme  
(SOPM 20-60-02)

C. Grease -- BMS 3-33 or MIL-G-23827 (SOPM 20-60-03)

D. Primer -- BMS 10-11, Type 1 (SOPM 20-60-02)

E. Primer -- BMS 10-79, Type 2 (SOPM 20-60-02)

F. Sealant -- BMS 5-95 (SOPM 20-60-04)

#### 4. Dimensioning Symbols

A. Standard True Position Dimensioning Symbols used in applicable repair procedures are shown in SOPM 20-00-00.

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FITTING ASSEMBLY – REPAIR 1-1

113T8316-9 thru -12, -19, -20

**NOTE:** Refer to REPAIR – GENERAL for a list of applicable standard practices. For repair which is only replacement of the original finish, refer to Refinish instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

- A. Remove the old bushings.
- B. If you find defects on the fitting surfaces, refer to par. 3 for repair instructions.
- C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03) with BMS 5-95 sealant.
- D. Machine the bore of the bushings to design dimensions and finish.
- E. Fillet seal all around the bushing flanges with BMS 5-95, class B sealant.

2. Bearing Replacement (90)

- A. Remove the old bearing.
- B. Install a replacement bearing with BMS 3-33 or MIL-G-23827 grease and roller swage it (SOPM 20-50-03).

3. Lug Holes for Bushings (Fig. 601)

- A. Machine as required, within repair limits, to remove defects.
- B. Penetrant examine (SOPM 20-20-02).
- C. Shot peen the bore as indicated.
- D. Make oversize bushings (Fig. 602, 603) to adjust for the material removed.
- E. Install the oversize bushings per par. 1.

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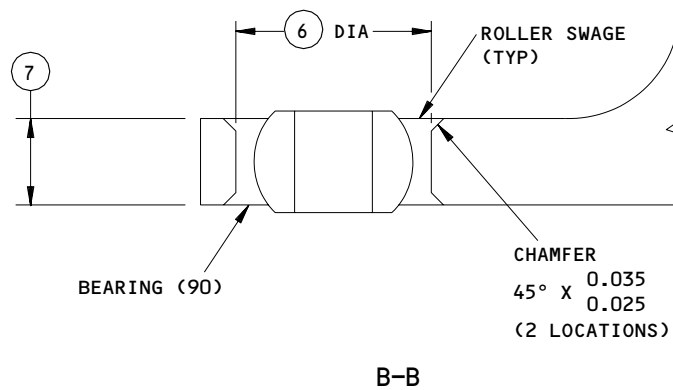
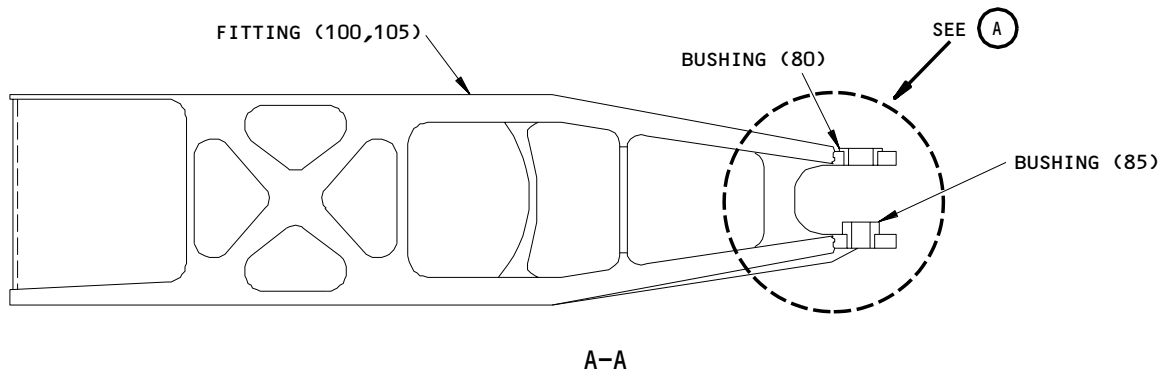
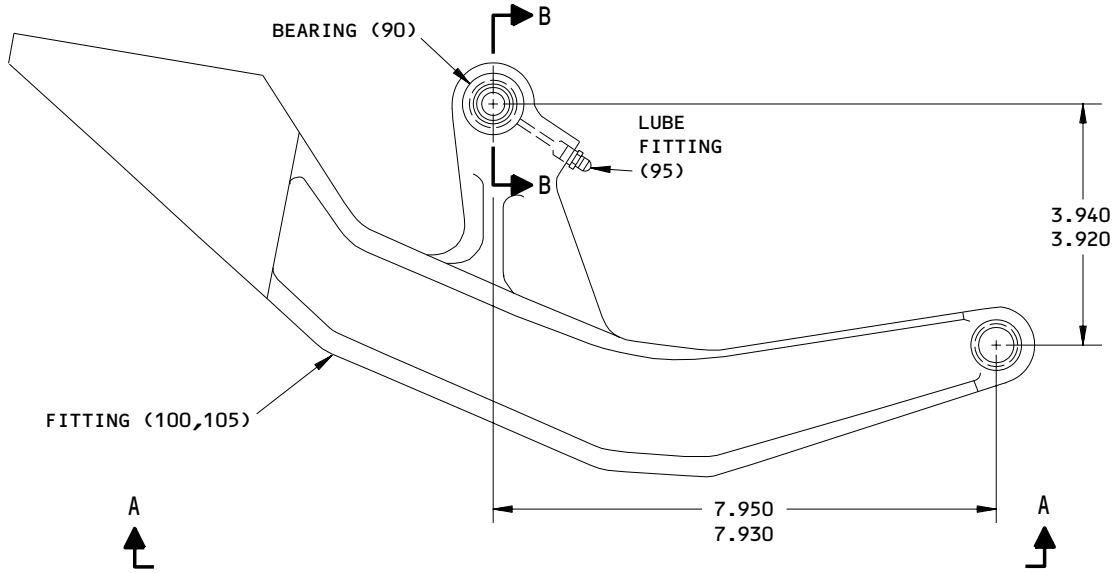
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113T8316-9 THRU -12,-19,-20  
Fitting Repair and Refinish  
Figure 601 (Sheet 1)

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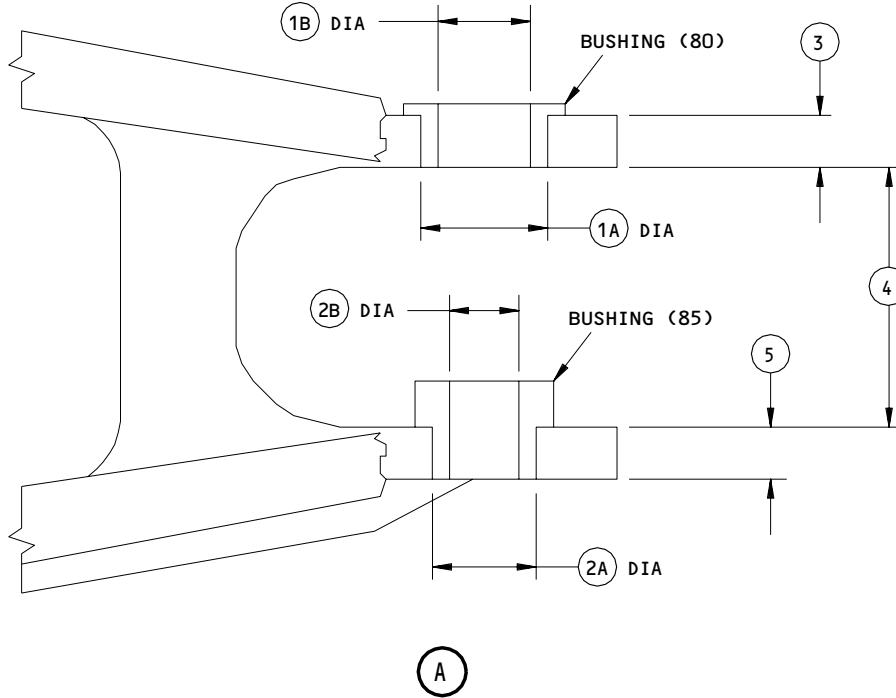
REPAIR 1-1

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REFERENCE NUMBER	1A	1B	2A	2B	3	4	5	6	7
DESIGN DIMENSION	0.6882 0.6875	0.5627 0.5620	0.5006 0.5000	0.3756 0.3750	0.260 0.240	1.210 1.190	0.260 0.240	0.9683 0.9677	0.430 0.420
REPAIR LIMIT	0.7482 1	----	0.5606 1	----	----	----	----	----	----

**REFINISH**

CHROMIC ACID ANODIZE AND APPLY BMS 10-11, TYPE 1 PRIMER (F-18.13) BUT NO PRIMER IN HOLES

1 LIMIT FOR INSTALLATION OF OVERSIZE BUSHINGS

**REPAIR**

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE  
 0.006 A2 INTENSITY

MATERIAL: AL ALLOY

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T8316-9 THRU -12,-19,-20  
 Fitting Repair and Refinish  
 Figure 601 (Sheet 2)

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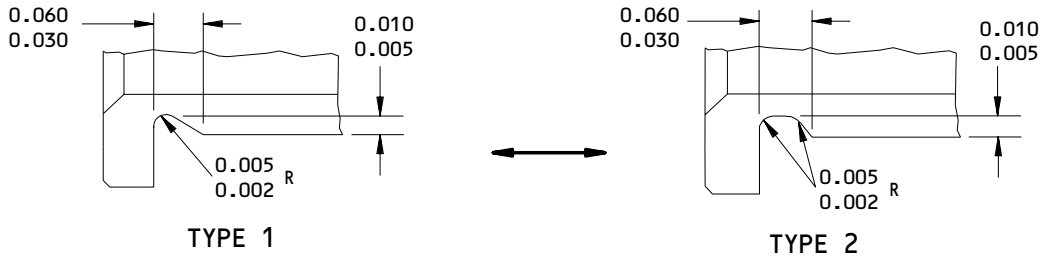
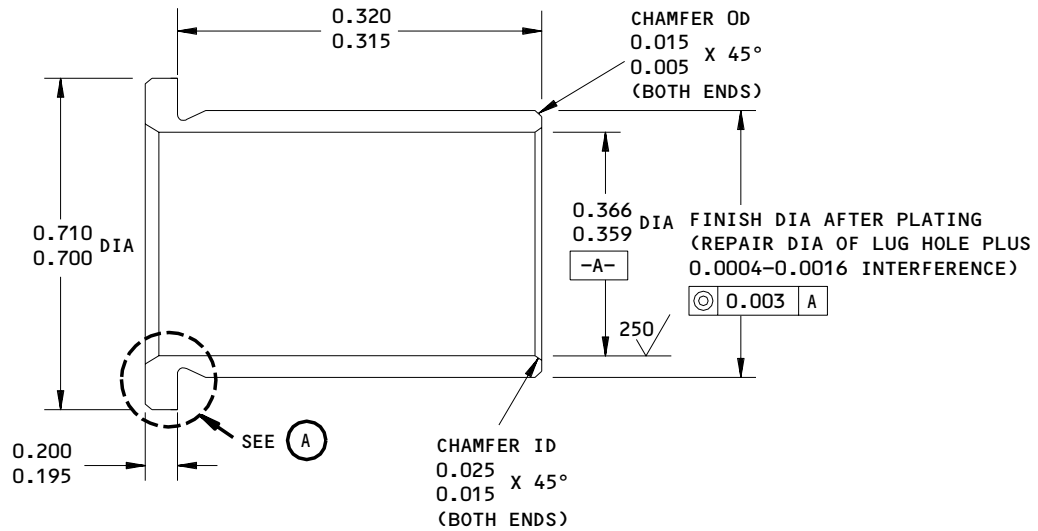
REPAIR 1-1

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UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

(A)

REPAIR

63/ ALL MACHINED SURFACES UNLESS SHOWN  
DIFFERENTLY

MATERIAL: 15-5PH, 180-200 KSI

FINISH: CADMIUM PLATE (F-15.06)

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (2A) FIG. 601

REPLACES BUSHING (85, IPL FIG. 1) 012T2400-23  
 Oversize Bushing Details  
 Figure 602

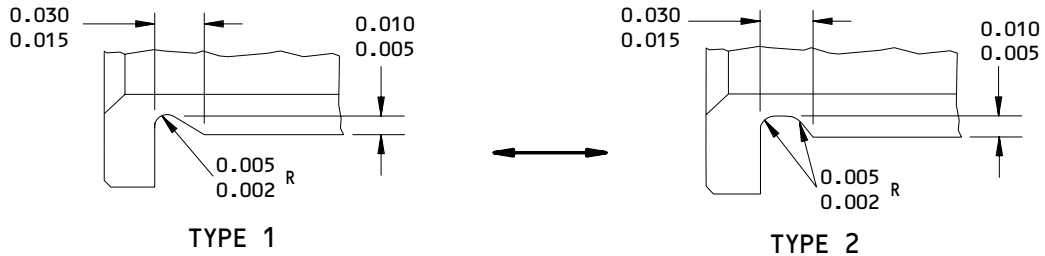
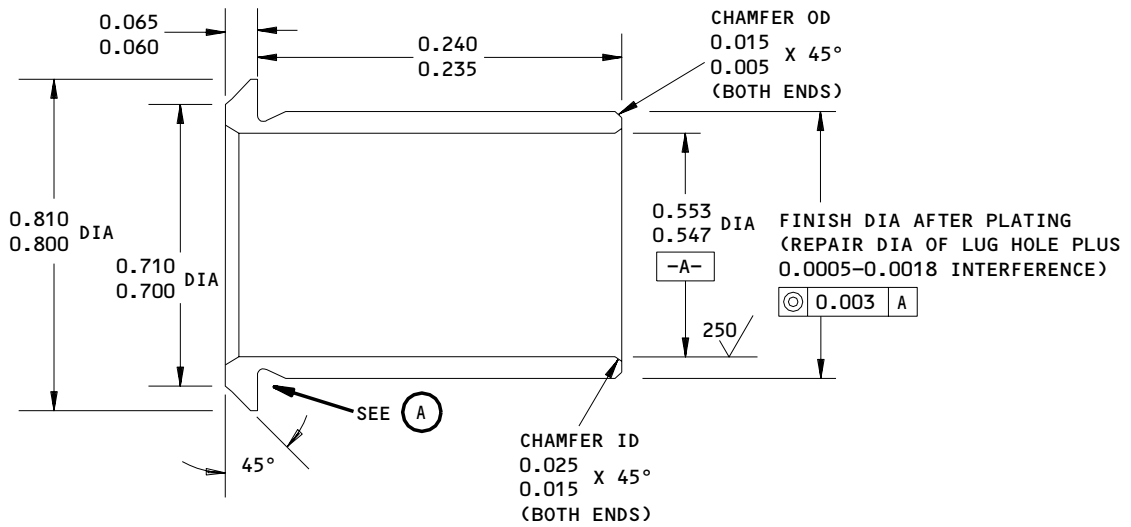
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UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL

(A)

**REPAIR**

63/ ALL MACHINED SURFACES UNLESS SHOWN  
 DIFFERENTLY

MATERIAL: AL-NI-BRZ PER AMS 4640

FINISH: CADMIUM PLATE (F-15.06)

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

HOLE LOCATION (1A) FIG. 601

REPLACES BUSHING (80, IPL FIG. 1) BACB28AM09B024A  
 Oversize Bushing Details  
 Figure 603

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REPAIR 1-1

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FITTING ASSEMBLY – REPAIR 2-1

113T8313-1, -3, -6

**NOTE:** Refer to REPAIR – GENERAL for a list of applicable standard practices. For repair which is only replacement of the original finish, refer to Refinish Instructions, Fig. 601.

1. Bushing Replacement (Fig. 601)

A. Remove the bushings.

B. If you find defects on the fitting surfaces, refer to par. 2 for repair instructions.

C. Install replacement bushings by the shrink-fit method (SOPM 20-50-03) with BMS 5-95 sealant.

D. Machine the bore of the bushings to design dimensions and finish.

E. Fillet seal all around the bushing flanges with BMS 5-95, class B sealant.

2. Lug Holes (Fig. 601)

A. Machine as required, within repair limits, to remove defects.

B. Penetrant examine (SOPM 20-20-02).

C. Shot peen the bore as indicated.

D. Make oversize bushings per Fig. 602 to adjust for the material removed.

E. Install the oversize bushings per par. 1.

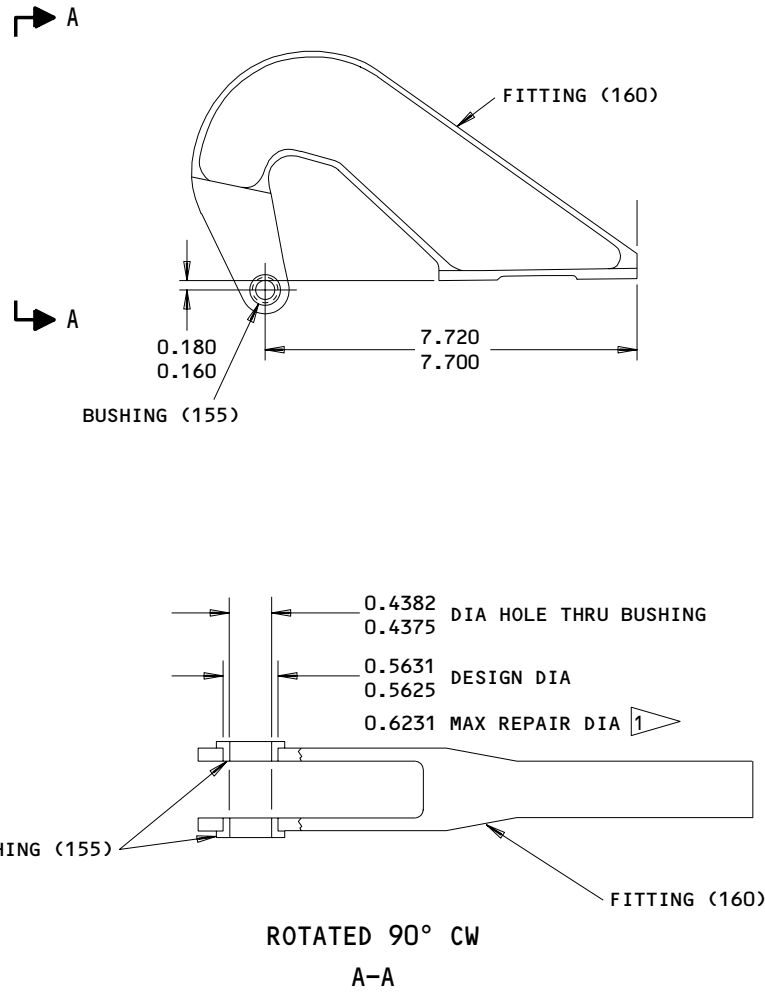
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REPAIR 2-1

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**REFINISH**

CHROMIC ACID ANODIZE AND APPLY PRIMER  
 BMS 10-11, TYPE 1 (F-18.13) BUT NO PRIMER  
 IN HOLES.

**REPAIR**

REF 1

125 ALL MACHINED SURFACES UNLESS SHOWN  
 DIFFERENTLY

SHOT PEEN: 0.023-0.055 SHOT SIZE  
 0.006 A2 INTENSITY  
 2.0 COVERAGE

ITEM NUMBERS REFER TO IPL FIG. 1

ALL DIMENSIONS ARE IN INCHES

113T8313-1,-3,-6  
 Fitting Repair and Refinish  
 Figure 601

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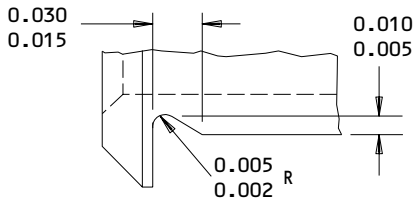
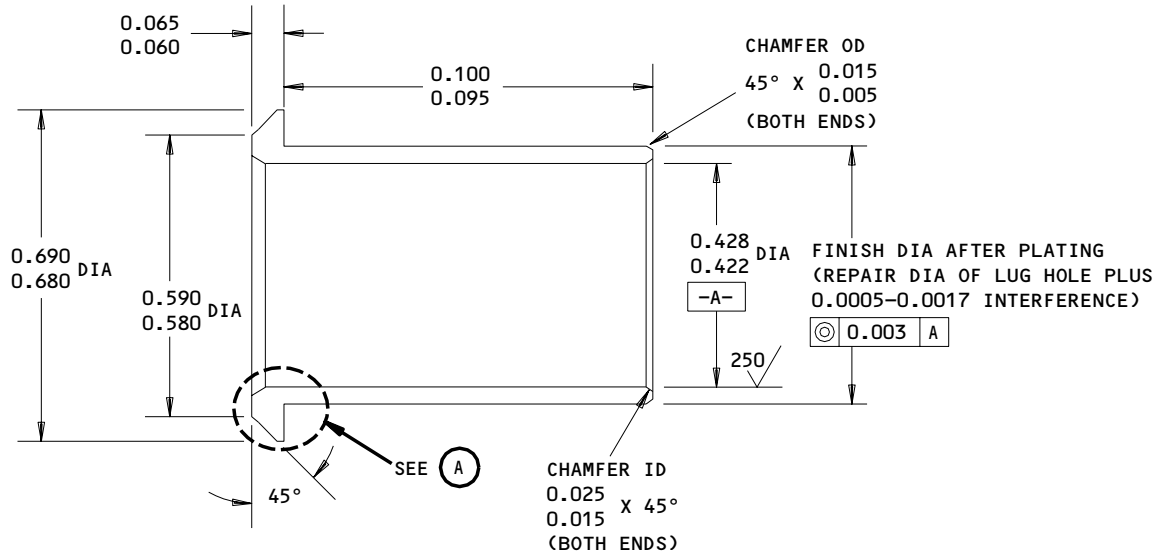
REPAIR 2-1

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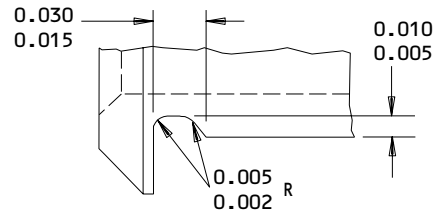
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TYPE 1



TYPE 2

UNDERCUT TYPE 1 OR TYPE 2 OPTIONAL



REPAIR

63/ ALL MACHINED SURFACES UNLESS SHOWN  
DIFFERENTLY

MATERIAL: ALUMINUM-NICKEL BRONZE PER AMS 4640

FINISH: CADMIUM PLATE (F-15.06)

DIMENSIONS APPLY AFTER PLATING

ALL DIMENSIONS ARE IN INCHES

REPLACES BUSHING (155, IPL FIG. 1) BACB28AM07B010A  
 Oversize Bushing Details  
 Figure 602

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REPAIR 2-1

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MISCELLANEOUS PARTS REFINISH – REPAIR 3-1

1. Repair of these parts is only replacement of the original finish. Refer to REPAIR – GENERAL for a list of applicable standard practices.

IPL FIG. & ITEM	MATERIAL	FINISH
<u>Fig. 1</u> Trunnion door assembly		Apply BMS 10-79, type 2 primer (F-19.46) all over. Apply BMS 10-11, type 2 enamel, BAC702 white gloss (F-21.03) on interior of door. Apply BMS 10-60, type 2 gloss enamel (F-19.39-XXX) in the color of the airline's color scheme on exterior surface and edges. Do not paint seals, bearings, or bushings.
Seal retainer (15)	Al alloy	Chromic acid anodize and apply BMS 10-11, type 1 primer (F-18.13), but no primer in holes.

Refinish Details  
 Figure 601

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REPAIR 3-1

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ASSEMBLY1. Materials

NOTE: Equivalent substitutes can be used.

A. Sealant -- BMS 5-95 (SOPM 20-60-04)

2. Assembly (IPL Fig. 1)

A. Use standard industry practices and these steps.

B. Install bolts (40, 45, 50, 55, 135) with wet BMS 5-95 sealant.

C. Do not apply primer or enamel between faying surface of shims (75, 150), fittings (100C, 100D, 105C, 105D, 160, 160A), and panel assemblies (175A, 180A) during assembly.

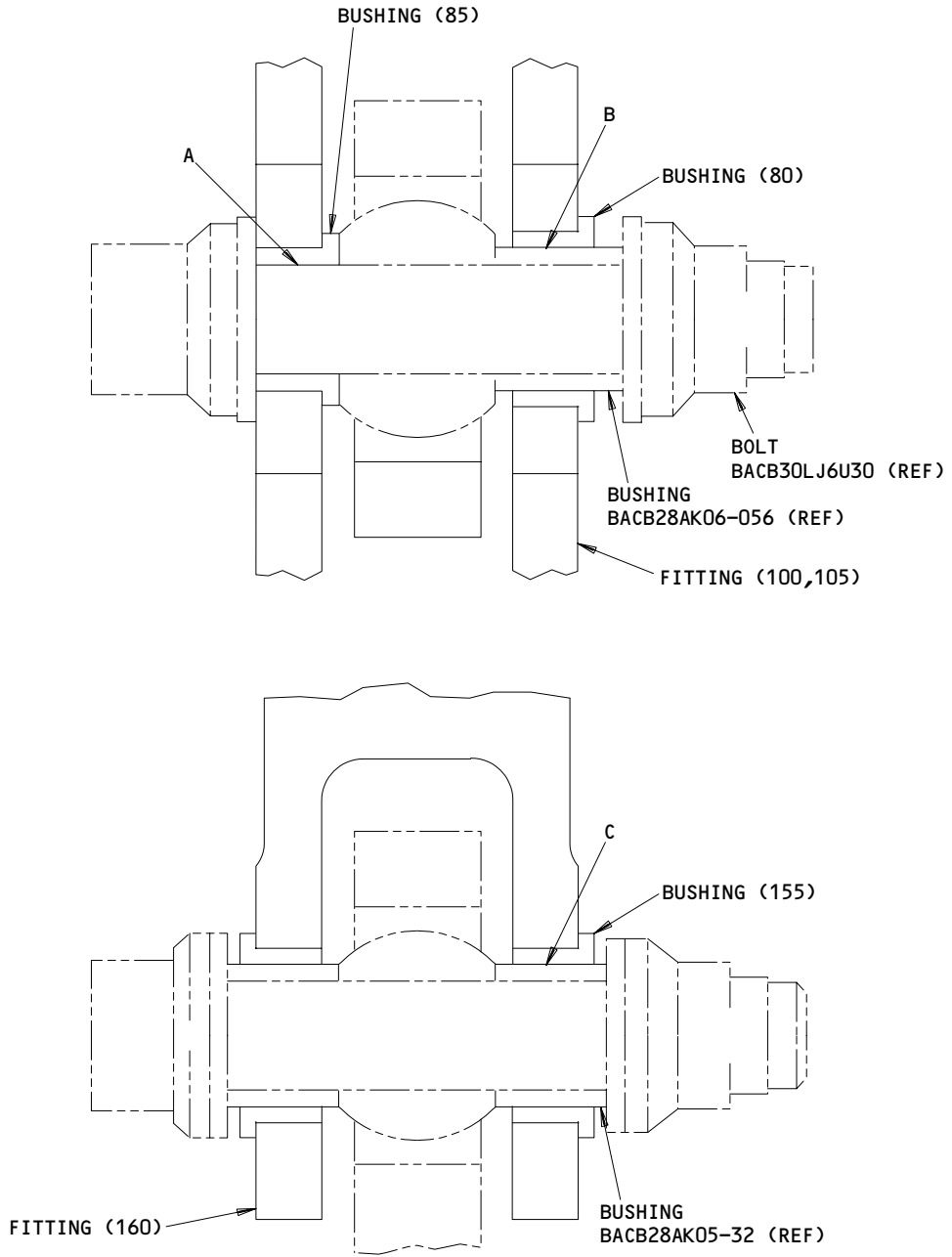
D. Electrically bond shim (150) between skin of door and fitting assembly (130) per SOPM 20-11-03.

NOTE: Shims (75, 150) thickness will be adjusted when the door is installed on the airplane, if the fittings were replaced.

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FITS AND CLEARANCES







ITEM NUMBERS REFER TO IPL FIG. 1

Fits and Clearances  
Figure 801 (Sheet 1)





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FITS AND CLEARANCES  
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REF LETTER	REF IPL	DESIGN DIMENSION*				SERVICE WEAR LIMIT*		
	FIG. 1, MATING ITEM NO.	DIMENSION		ASSEMBLY CLEARANCE		DIMENSION		MAXIMUM CLEARANCE
		MIN	MAX	MIN	MAX	MIN	MAX	
A	ID 85	0.3750	0.3756	0.0005	0.0016	0.3701	0.3800	0.0055
	OD 	0.3740	0.3745					
B	ID 80	0.5620	0.5627	0.0005	0.0017	0.5577	0.5665	0.0050
	OD 	0.5610	0.5615					
C	ID 155	0.4375	0.4382	0.0005	0.0017	0.4332	0.4420	0.0050
	OD 	0.4365	0.4370					
D	ID 90	0.3750	0.3754	0.0005	0.0014	0.3699	0.3800	0.0055
	OD 	0.3740	0.3745					

\* ALL DIMENSIONS ARE IN INCHES

-  INSTALLATION BOLT BACB30LU6U30
-  INSTALLATION BUSHING BACB28AK06-056
-  INSTALLATION BOLT BACB30LJ5U18
-  INSTALLATION BOLT BACB30LJ6U21

Fits and Clearances  
 Figure 801 (Sheet 2)

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FITS AND CLEARANCES  
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ILLUSTRATED PARTS LIST

1. This section lists and illustrates replaceable or repairable component parts. The Illustrated Parts Catalog contains a complete explanation of the Boeing part numbering system.

2. Indentures show parts relationships as follows:

Assembly

Detail Parts for Assembly

Subassembly

Attaching Parts for Subassembly

Detail Parts for Subassembly

Detail Installation Parts (Included only if installation parts may be returned to shop as part of assembly)

3. One use code letter (A, B, C, etc.) is assigned in the EFF CODE column for each variation of top assembly. All listed parts are used on all top assemblies except when limitations are shown by use code letter opposite individual part entries.

4. Letter suffixes (alpha-variants) are added to item numbers for optional parts, Service Bulletin modification parts, configuration differences (except left- and right-hand parts), product improvement parts, and parts added between two sequential item numbers. The alpha-variant is not shown on illustrations when appearance and location of all variants of the part is the same.

5. Service Bulletin modifications are shown by the notations PRE SB XXXX and POST SB XXXX.

A. When a new top assembly part number is assigned by Service Bulletin, the notations appear at the top assembly level only. The configuration differences at detail part level are then shown by use code letter.

B. When the top assembly part number is not changed by the Service Bulletin, the notations appear at the detail part level.

6. Parts Interchangeability

Optional  
(OPT)

The parts are optional to and interchangeable with other parts having the same item number.

Supersedes, Superseded By  
(SUPSDS, SUPSD BY)

The part supersedes and is not interchangeable with the original part.

Replaces, Replaced By  
(REPLS, REPLD BY)

The part replaces and is interchangeable with, or is an alternate to, the original part.

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7. Boeing Proprietary Color-Coded Parts

- A. Color-coded parts are identified with an alpha "SP" suffix. This entry includes all of the color codes for this part number. When you make an order for this part, be sure to include the airplane registry number for the airplane that will use this part.

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 MAINTENANCE MANUAL
VENDORS

08524 DEUTSCH FASTENER CORP SEE CODE V97928

09455 BFM TRANSPORT DYNAMICS CORP  
 3131 WEST SEGERSTROM AVENUE PO BOX 1953  
 SANTA ANA, CALIFORNIA 92702-1953

11815 CHERRY AEROSPACE FASTENERS DIV OF TEXTRON  
 1224 EAST WARNER AVENUE PO BOX 2157  
 SANTA ANA, CALIFORNIA 92707-0157

15653 KAYNAR TECHNOLOGY KAYNAR DIV  
 800 SOUTH STATE COLLEGE BLVD PO BOX 3001  
 FULLERTON, CALIFORNIA 92634-3001

15860 NEW HAMPSHIRE BALL BEARINGS, INCORPORATED ASTRO DIVISION  
 155 LEXINGTON AVENUE  
 LACONIA, NEW HAMPSHIRE 03246-2937

27238 BRISTOL INDUSTRIES  
 630 EAST LAMBERT ROAD PO BOX 630  
 BREA, CALIFORNIA 92621-4119

50294 NEW HAMPSHIRE BALL BEARINGS INC  
 9730 INDEPENDENCE AVENUE PO BOX 2515  
 CHATSWORTH, CALIFORNIA 91311-4323

52828 REPUBLIC FASTENER MFG CORP  
 1300 RANCHO CONEJO BLVD  
 NEWBURY PARK, CALIFORNIA 91320-1405

56878 SPS TECHNOLOGIES INC AEROSPACE AND INDUSTRIAL PRODUCTS DIV  
 HIGHLAND AVENUE  
 JENKINTOWN, PENNSYLVANIA 19046

62554 SIMMONDS MECAERO FASTENERS INC  
 1734 SEQUOIA AVENUE  
 ORANGE, CALIFORNIA 92668

71087 BOOTS ACFT NUT DIV TOWNSEND CO SEE TEXTRON INC CHERRY  
 FASTENER TOWNSEND DIV V11815

72962 HARVARD INDUSTRIES INC  
 3 WERNER WAY SUITE 210  
 LEBANON, NEW JERSEY 08833

73134 IMO INDUSTRIES INC HEIM BEARINGS DIV  
 60 ROUND HILL ROAD PO BOX 430  
 FAIRFIELD, CONNECTICUT 06430

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VENDORS

73197 HI-SHEAR TECHNOLOGY CORP  
2600 SKYPARK DRIVE  
TORRANCE, CALIFORNIA 90509

80539 SPS TECHNOLOGIES INC AEROSPACE PRODUCTS DIV  
2701 SOUTH HARBOR BOULEVARD PO BOX 1259  
SANTA ANA, CALIFORNIA 92702-1259

92215 FAIRCHILD IND INC FAIRCHILD AEROSPACE FASTENER DIV  
3010 W LOMITA BLVD  
TORRANCE, CALIFORNIA 90505-5102

97613 SARGENT CONTROLS & AEROSPACE/KAHR BEARING DIV  
5675 W BURLINGAME RD  
TUCSON, ARIZONA 85743

97928 DEUTSCH FASTENER CORP  
3969 PARAMONT BOULEVARD  
LAKEWOOD, CALIFORNIA 90712-4193

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**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
ABWEN06VC		1	90	1
AG6V29C		1	90	1
AN3DD3A		1	211	8
AN315D3R		1	213	8
AN960PD10L		1	22	11
		1	212	8
AN960PD516L		1	60	6
		1	140	4
BACB10EN06GC		1	90	1
BACB28AM07B010A		1	155	2
BACB28AM09B024A		1	80	1
BACB30LU5-28		1	55A	2
BACB30LU5-30		1	45A	1
BACB30LU5-31		1	50A	2
BACB30LU5-33		1	40A	1
BACB30NN3K3		1	20	11
BACB30NN5K29		1	135	4
BACB30SW5K28		1	55	2
BACB30SW5K30		1	45	1
BACB30SW5K31		1	50	2
BACB30SW5K33		1	40	1
BACN10HR5CS		1	65	6
BACN10JC3		1	25	11
BACN10JC5		1	145	4
BACR15BA4D		1	170	16
BACR15BB4D		1	165	16
BACS40R26D41F		1	150	1
BACS40R38D40F		1	75	1
BH003025CS		1	65	6
BH00303-5		1	65	6
BH003035		1	65	6
BMN10HR5CS		1	65	6
BMN5024CPD3-5		1	65	6
BMN5024CPD35		1	65	6
BMN5024CPD5		1	65	6
BRH10A3		1	25	11
CR59065CS		1	65	6
CR59085		1	65	6
H10-3BAC		1	25	11
H39953		1	65	6
H965CS		1	65	6
KWB6-48-50		1	90	1
LHB06ENGC		1	90	1
MS15001-1		1	95	1
MS27253F3		1	265	1
NS202101-02		1	25	11

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PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
RMLH225CS		1	65	6
RMLH9075-3W		1	25	11
SL705095		1	65	6
T6S1032J		1	25	11
VN303A02		1	25	11
012T2400-23		1	85	1
03-526-06E002C		1	90	1
109LH90315		1	65	6
113T8301-11		1	10A	1
113T8301-15SP		1	1D	RF
113T8301-16SP		1	5D	RF
113T8301-17		1	1E	RF
113T8301-18		1	5E	RF
113T8301-19		1	27	1
113T8301-20		1	28	1
113T8301-21SP		1	1F	RF
113T8301-22SP		1	5F	RF
113T8301-23		1	27B	1
113T8301-24		1	28B	1
113T8301-25		1	27C	1
113T8301-26		1	28C	1
113T8301-27SP		1	1H	RF
113T8301-28SP		1	5H	RF
113T8301-29G		1	1J	RF
113T8301-3		1	15	1
113T8301-30G		1	5J	RF
113T8302-13		1	215	1
113T8302-14		1	220	1
113T8302-29		1	215A	1
113T8302-3		1	255	1
113T8302-30		1	220A	1
113T8302-33		1	175A	1
113T8302-34		1	180A	1
113T8302-35		1	195A	1
113T8302-36		1	200A	1
113T8302-39		1	235B	1
113T8302-4		1	260	1
113T8302-40		1	240B	1
113T8302-41		1	225B	1
113T8302-42		1	230B	1
113T8302-43		1	245B	1
113T8302-44		1	250B	1
113T8302-45		1	235C	1
113T8302-46		1	240C	1
113T8302-47		1	225C	1

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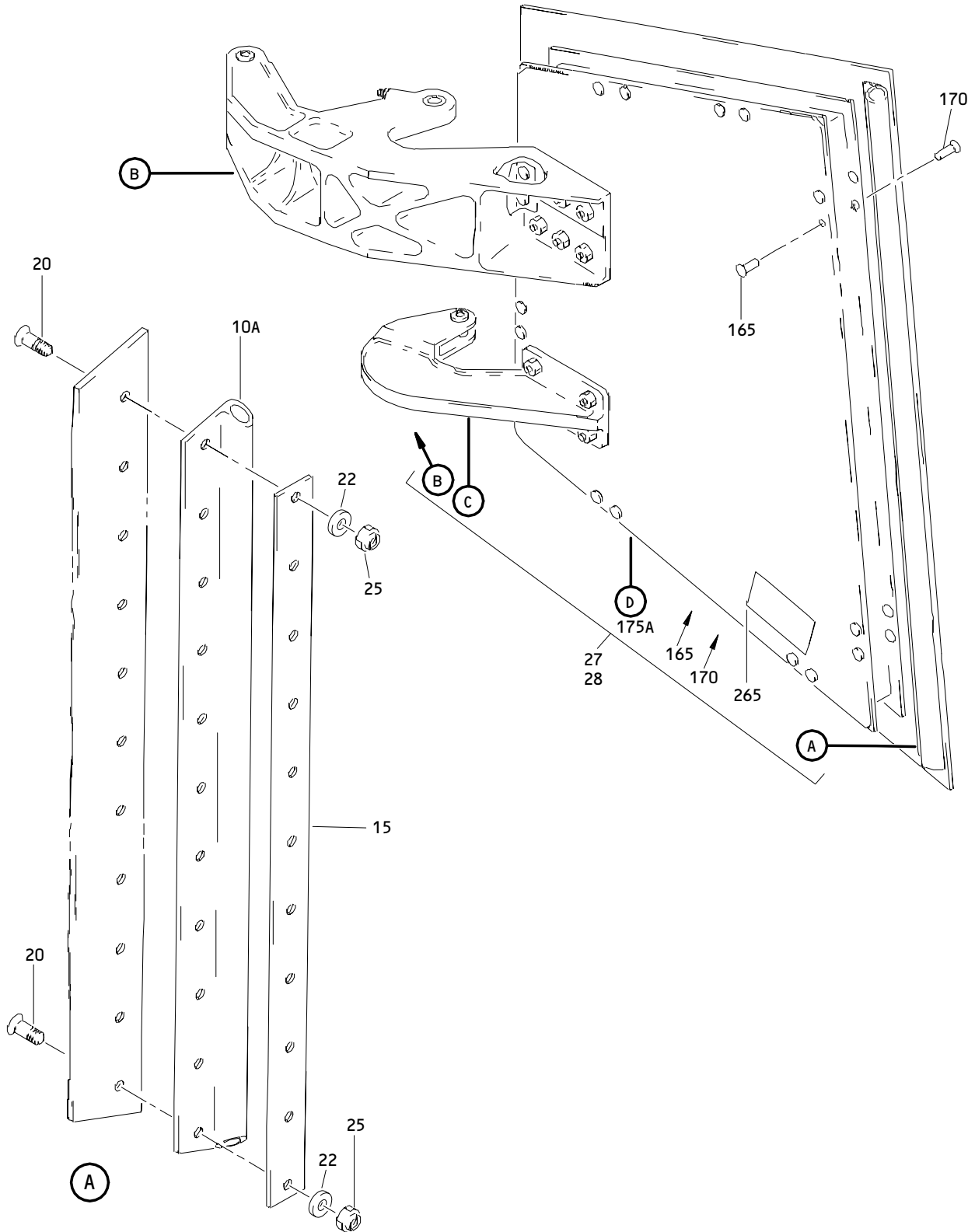

**BOEING**  
 COMPONENT  
 MAINTENANCE MANUAL

PART NUMBER	AIRLINE PART NO.	FIG.	ITEM	TTL REQ
113T8302-48		1	230C	1
113T8302-49		1	245C	1
113T8302-50		1	250C	1
113T8302-7		1	190	1
113T8302-8		1	185	1
113T8311-1		1	205	1
113T8311-2		1	210	1
113T8313-1		1	130	1
113T8313-2		1	160	1
113T8313-3		1	130A	1
113T8313-4		1	160A	1
113T8313-6		1	130B	1
113T8313-7		1	160B	1
113T8316-10		1	35D	1
113T8316-11		1	30C	1
113T8316-12		1	35C	1
113T8316-13		1	100D	1
113T8316-14		1	105D	1
113T8316-15		1	100C	1
113T8316-16		1	105C	1
113T8316-17		1	100E	1
113T8316-18		1	105E	1
113T8316-19		1	30F	1
113T8316-20		1	35F	1
113T8316-9		1	30D	1
67832AS5		1	65	6
67832AS524		1	65	6
96-02		1	25	11

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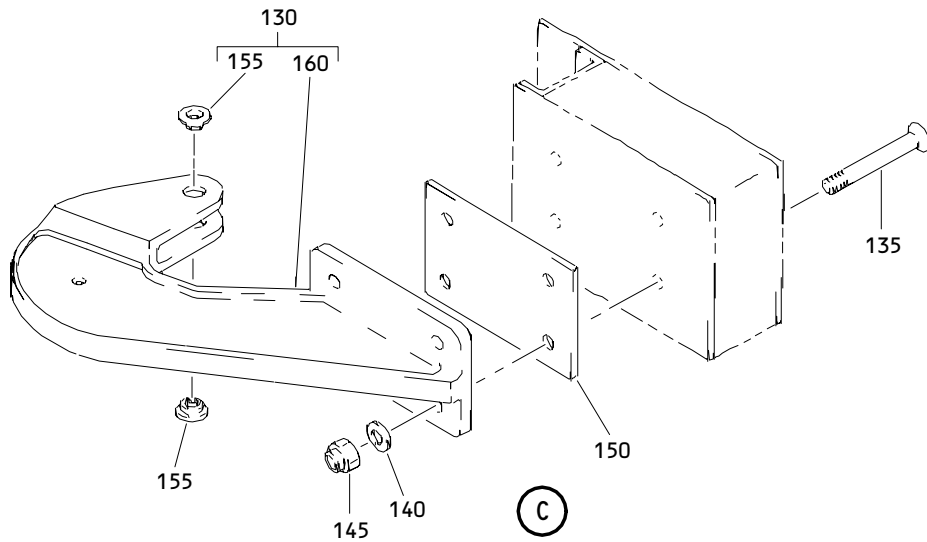
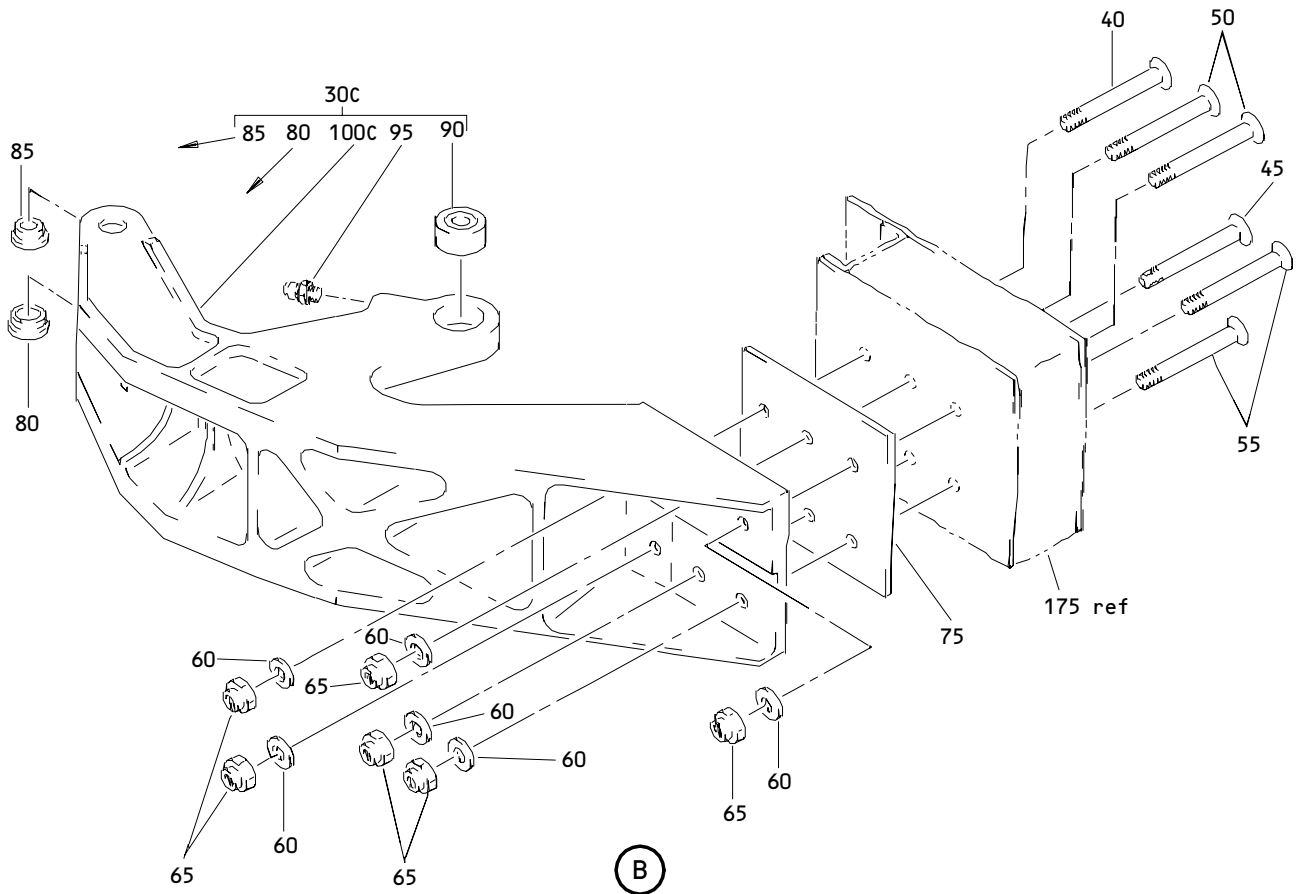




Trunnion Door Assembly  
 Figure 1 (Sheet 1)

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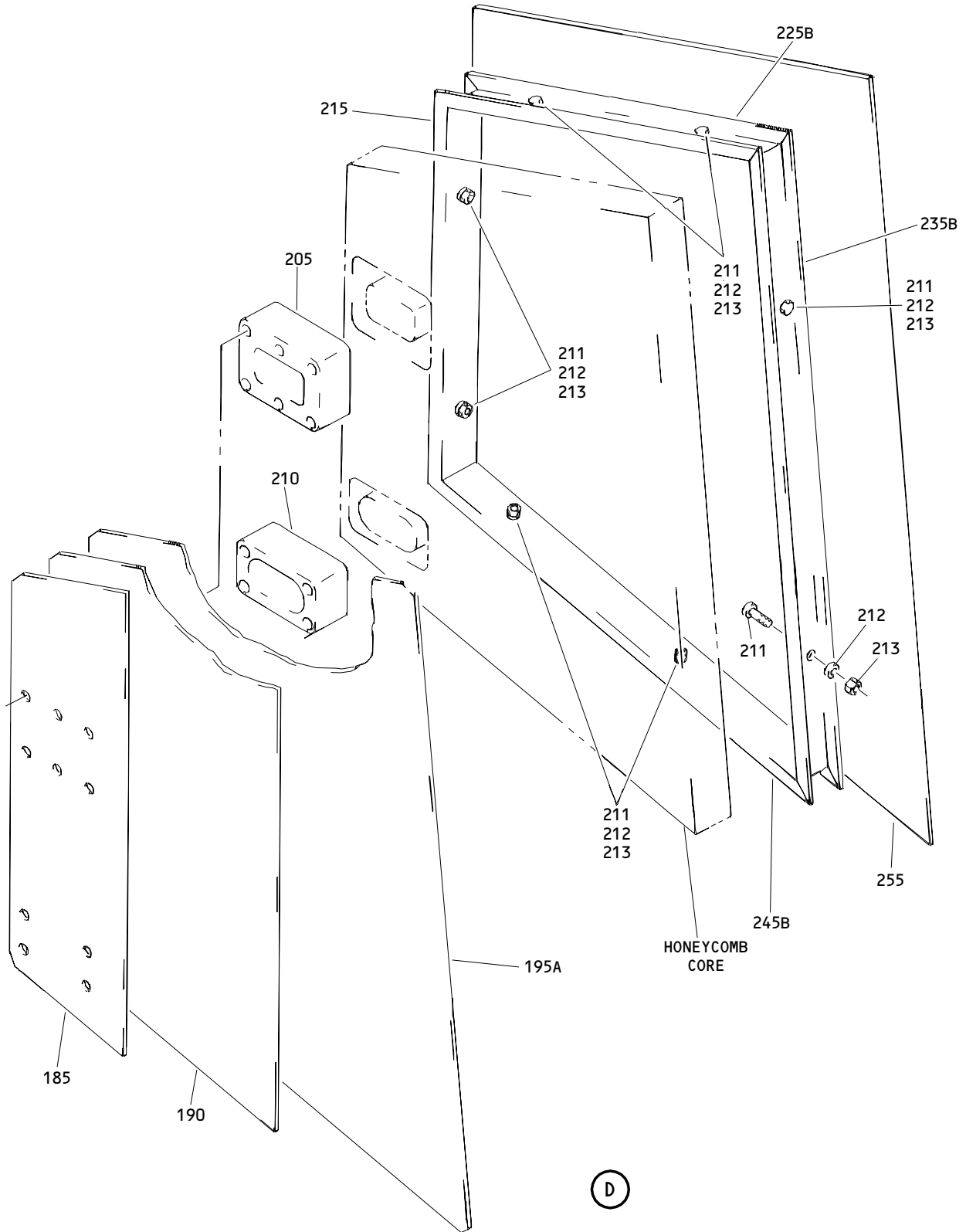
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Trunnion Door Assembly  
 Figure 1 (Sheet 2)

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Trunnion Door Assembly  
 Figure 1 (Sheet 3)

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 COMPONENT  
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-1	113T8301-1SP		DELETED		
-1A	113T8301-7SP		DELETED		
-1B	113T8301-9SP		DELETED		
-1C	113T8301-13		DELETED		
R -1D	113T8301-15SP		DOOR ASSY-TRUN (LH)	A	RF
R -1E	113T8301-17		DOOR ASSY-TRUN (VARIABLE) (LH)	B	RF
-1F	113T8301-21SP		DOOR ASSY-TRUN (LH)	E	RF
-1G	113T8301-27		DELETED		
-1H	113T8301-27SP		DOOR ASSY-TRUN (LH)	G	RF
R -1J	113T8301-29G		DOOR ASSY-TRUN (LH)	G	RF
-5	113T8301-2SP		DELETED		
-5A	113T8301-8SP		DELETED		
-5B	113T8301-10SP		DELETED		
-5C	113T8301-14		DELETED		
R -5D	113T8301-16SP		DOOR ASSY-TRUN (RH)	C	RF
R -5E	113T8301-18		DOOR ASSY-TRUN (VARIABLE) (RH)	D	RF
-5F	113T8301-22SP		DOOR ASSY-TRUN (RH)	F	RF
-5G	113T8301-28		DELETED		
-5H	113T8301-28SP		DOOR ASSY-TRUN (RH)	H	RF
R -5J	113T8301-30G		DOOR ASSY-TRUN (RH)	K	RF
10	113T8301-5		DELETED		
R 10A	113T8301-11		.SEAL		1
R 15	113T8301-3		.RETAINER-SEAL		1
			ATTACHING PARTS		
R 20	BACB30NN3K3		.BOLT		11
-20A	BACB30VF3K3		DELETED		
22	AN960PD10L		.WASHER		11
R 25	H10-3BAC		.NUT-		11
			(V15653)		
			(SPEC BACN10JC3)		
			(OPT NS202101-02		
			(V80539))		
			(OPT RMLH9075-3W		
			(V72962))		
			(OPT T6S1032J		
			(V71087))		
			(OPT VN303A02		
			(V92215))		
			(OPT 96-02		
			(V80539))		
			(OPT BRH10A3		
			(V52828))		
			-----*		

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
27	113T8301-19		.DOOR ASSY-SUB	A,B	1
-27A	113T8301-19		.DOOR ASSY-SUB (LIMITED)	E	1
-27B	113T8301-23		.DOOR ASSY-SUB (LIMITED)	E	1
-27C	113T8301-25		.DOOR ASSY-SUB	G,J	1
28	113T8301-20		.DOOR ASSY-SUB	C,D	1
-28A	113T8301-20		.DOOR ASSY-SUB (LIMITED)	F	1
-28B	113T8301-24		.DOOR ASSY-SUB (LIMITED)	F	1
-28C	113T8301-26		.DOOR ASSY-SUB	H,K	1
30	113T8312-1		DELETED		
30A	113T8316-1		DELETED		
-30B	113T8316-7		DELETED		
R 30C	113T8316-11		..FITTING ASSY- (OPT ITEM 30D)	A,B,E	1
R -30D	113T8316-9		..FITTING ASSY- (OPT ITEM 30C)	A,B,E	1
-30E	113T8316-9		DELETED		
-30F	113T8316-19		..FITTING ASSY	G,J	1
-35	113T8312-2		DELETED		
-35A	113T8316-2		DELETED		
-35B	113T8316-8		DELETED		
R -35C	113T8316-12		..FITTING ASSY- (OPT ITEM 35D)	C,D,F	1
R -35D	113T8316-10		..FITTING ASSY- (OPT ITEM 35C)	C,D,F	1
-35E	113T8316-10		DELETED		
R -35F	113T8316-20		..FITTING ASSY ATTACHING PARTS	H,K	1

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 COMPONENT  
 MAINTENANCE MANUAL

FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-40	BACB30SW5K33		..BOLT- (OPT ITEM 40A)		1
-40A	BACB30LU5-33		..BOLT- (OPT ITEM 40)		1
R 45	BACB30SW5K30		..BOLT- (V08524) (SPEC BACB30SW5K30) (OPT BACB30SW5K30 (V73197)) (OPT BACB30SW5K30 (V80539)) (OPT BACB30SW5K30 (V92215)) (OPT ITEM 45A)		1
45A	BACB30LU5-30		..BOLT- (OPT ITEM 45)		1
R 50	BACB30SW5K31		..BOLT- (OPT ITEM 50A)		2
-50A	BACB30LU5-31		..BOLT- (OPT ITEM 50)		2
R 55	BACB30SW5K28		..BOLT- (OPT ITEM 55A)		2
-55A	BACB30LU5-28		..BOLT- (OPT ITEM 55)		2
R 60	AN960PD516L		..WASHER		6

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE	EFF CODE	QTY PER ASSY
R 01-65	BMN5024CPD5		1234567 ..NUT- (V08524) (SPEC BACN10HR5CS) (OPT 67832AS524 (V56878)) (OPT 67832AS524 (V56878)) (OPT BMN5024CPD3-5 (V97928)) (OPT BH00303-5 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT BH003035 (V27238)) (OPT BMN5024CPD35 (V97928)) (OPT CR59085 (V62554)) (OPT H39953 (V15653)) (OPT SL705095 (V11815)) (OPT 109LH90315 (V72962)) (OPT 67832AS5 (V56878)) (OPT BH003025CS (V27238)) (OPT BMN10HR5CS (V97928)) (OPT CR59065CS (V62554)) (OPT H965CS (V15653)) (OPT RMLH225CS (V72962))		6
R 70	BACF3T01F8-8		DELETED		
R 75	BACS40R38D40F		..SHIM -----*		1
R 80	BACB28AM09B024A		...BUSHING		1
R 85	012T2400-23		...BUSHING		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
R 01-90	ABWEN06VC		...BEARING- (V50294) (SPEC BACB10EN06GC) (OPT AG6V29C (V15860)) (OPT KWB6-48-50 (V97613)) (OPT LHBO6ENGC (V73134)) (OPT 03-526-06E002C (V09455))		1
R 95	MS15001-1		...FITTING-LUBE		1
100	113T8312-3		DELETED		
100A	113T8316-3		DELETED		
-100B	113T8316-5		DELETED		
R 100C	113T8316-15		...FITTING- (USED ON ITEM 30C)	A,B,E	1
R -100D	113T8316-13		...FITTING- (USED ON ITEMS 30D, 30E)	A,B,E	1
-100E	113T8316-17		...FITTING	G,J	1
-105	113T8312-4		DELETED		
-105A	113T8316-4		DELETED		
-105B	113T8316-6		DELETED		
R -105C	113T8316-16		...FITTING- (USED ON ITEM 35C)	C,D,F	1
R -105D	113T8316-14		...FITTING- (USED ON ITEMS 35D, 35E)	C,D,F	1
-105E	113T8316-18		...FITTING	H,K	1
110	940CW21-6		DELETED		
115	NAS623-3-5		ATTACHING PARTS		
120	AN960-10L		DELETED		
125	H10-3BAC		DELETED		
R 130	113T8313-1		..FITTING ASSY- (REPLD BY ITEM 130A) (USED ON ITEMS 27, 27A, 28, 28A)	A-F	1
R -130A	113T8313-3		..FITTING ASSY- (REPLS ITEM 130) (USED ON ITEMS 27, 27A, 28, 28A)	A-F	1
-130B	113T8313-6		..FITTING ASSY- (USED ON ITEMS 27B, 27C, 28B, 28C)	E,F	1
R 135	BACB30NN5K29		..BOLT		4

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 140	AN96OPD516L		..WASHER		4
R 145	BACN10JC5		..NUT		4
R 150	BACS40R26D41F		..SHIM		1
			-----*-----		
R 155	BACB28AM07B010A		...BUSHING		2
R 160	113T8313-2		...FITTING- (USED ON ITEM 130)	A-F	1
R -160A	113T8313-4		...FITTING- (USED ON ITEM 130A)	A-F	1
-160B	113T8313-7		...FITTING- (USED ON ITEM 130B)	E-K	1
R 165	BACR15BB4D		..RIVET- (SIZE DETERMINE ON INST)		16
R 170	BACR15BA4D		..RIVET- (SIZE DETERMINE ON INST)		16
175	113T8302-1		DELETED		
R 175A	113T8302-33		..PANEL ASSY-BONDED TRUN DOOR	A,B,E ,G,J	1
-180	113T8302-2		DELETED		
R -180A	113T8302-34		..PANEL ASSY-BONDED TRUN DOOR	C,D,F ,H,K	1
R 185	113T8302-8		...DOUBLER		1
R 190	113T8302-7		...DOUBLER		1
195	113T8302-5		DELETED		
R 195A	113T8302-35		...SKIN-INNER	A,B,E ,G,J	1
-200	113T8302-6		DELETED		
R -200A	113T8302-36		...SKIN-INNER	C,D,F ,H,K	1
R 205	113T8311-1		...FITTING		1
R 210	113T8311-2		...FITTING		1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
R 211	AN3DD3A		...BOLT		8
R 212	AN960PD10L		...WASHER		8
R 213	AN315D3R		...NUT		8
R 215	113T8302-13		...PROTECTOR-EDGE (OPT ITEM 215A)	A,B,E	1
R -215A	113T8302-29		...PROTECTOR-EDGE (OPT ITEM 215)	A,B,E	1
R -220	113T8302-14		...PROTECTOR-EDGE (OPT ITEM 220A)	C,D,F	1
R -220A	113T8302-30		...PROTECTOR-EDGE (OPT ITEM 220)	C,D,F	1
	225	113T8302-11	DELETED		
	-225A	113T8302-27	DELETED		
R 225B	113T8302-41		...PROTECTOR-EDGE (OPT ITEM 225C)	A,B,E	1
R -225C	113T8302-47		...PROTECTOR-EDGE (OPT ITEM 225B)	A,B,E	1
	-230	113T8302-12	DELETED		
	-230A	113T8302-28	DELETED		
R -230B	113T8302-42		...PROTECTOR-EDGE (OPT ITEM 230C)	C,D,F	1
R -230C	113T8302-48		...PROTECTOR-EDGE (OPT ITEM 230B)	C,D,F	1
	235	113T8302-9	DELETED		
	-235A	113T8302-25	DELETED		
R 235B	113T8302-39		...PROTECTOR-EDGE (OPT ITEM 235C)	A,B,E ,G,J	1
R -235C	113T8302-45		...PROTECTOR-EDGE (OPT ITEM 235B)	A,B,E ,G,J	1

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FIG. & ITEM	PART NO.	AIRLINE PART NUMBER	NOMENCLATURE 1234567	EFF CODE	QTY PER ASSY
01-					
-240	113T8302-10		DELETED		
-240A	113T8302-26		DELETED		
R -240B	113T8302-40		...PROTECTOR-EDGE (OPT ITEM 240C)	C,D,F ,H,K	1
R -240C	113T8302-46		...PROTECTOR-EDGE (OPT ITEM 240B)	C,D,F ,H,K	1
245	113T8302-15		DELETED		
-245A	113T8302-31		DELETED		
R 245B	113T8302-43		...PROTECTOR-EDGE (OPT ITEM 245C)	A,B,E ,G,J	1
R -245C	113T8302-49		...PROTECTOR-EDGE (OPT ITEM 245B)	A,B,E ,G,J	1
-250	113T8302-16		DELETED		
-250A	113T8302-32		DELETED		
R -250B	113T8302-44		...PROTECTOR-EDGE (OPT ITEM 250C)	C,D,F ,H,K	1
R -250C	113T8302-50		...PROTECTOR-EDGE (OPT ITEM 250B)	C,D,F ,H,K	1
R 255	113T8302-3		...SKIN-OUTER	A,B,E ,G,J	1
R -260	113T8302-4		...SKIN-OUTER	C,D,F ,H,K	1
R 265	MS27253F3		..PLATE-IDENT		1

- Item Not Illustrated

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